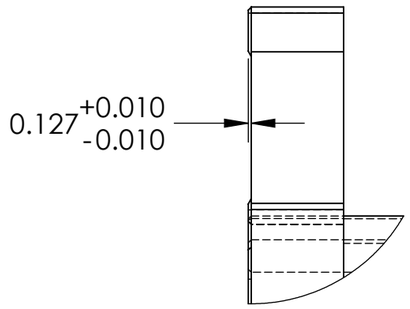
NOTES CONTINUED:

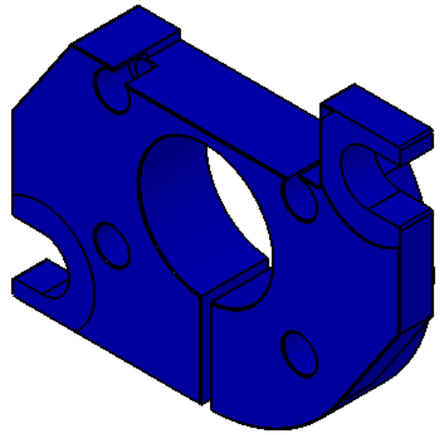
5. SCRIBE, ENGRAVE, OR MECHANICALLY STAMP (NO INKS OR DYES) DRAWING PART NUMBER, REVISION (AND VARIANT OR "TYPE" IF APPLICABLE) ON NOTED SURFACE OF PART FOLLOWED ON THE NEXT LINE WITH A THREE DIGIT SERIAL NUMBER. SERIAL NUMBERS START AT 001 FOR THE FIRST ARTICLE AND PROCEED CONSECUTIVELY. USE MINIMUM 0.12" HIGH CHARACTERS, UNLESS THE SIZE OF THE PART DICTATES SMALLER CHARACTERS. A VIBRATORY TOOL MAY BE USED. EXAMPLE: DXXXXXXX-VY, TYPE-XX, S/N XXX

6. APPROXIMATE WEIGHT = X.XXX LB.
7. MACHINE ALL SURFACES TO REMOVE OXIDES AND MILL FINISH, USE OF ABRASIVE REMOVAL TECHNIQUES IS NOT ALLOWED.
8. ALL PARTS SHALL BE MANUFACTURED IN ACCORDANCE WITH LIGO SPECIFICATION E0900364.

9. ALL HELI-COIL HOLES TO BE PREPARED ACCORDING TO EMHART HELI-COIL PRODUCT CATALOG, HC2000, REV 4
10. ALL HELI-COIL INSERTS TO BE INSTALLED BY LIGO PERSONNEL, AFTER DELIVERY OF FINISHED PARTS, USE NITRONIC 60 THREADED INSERTS.

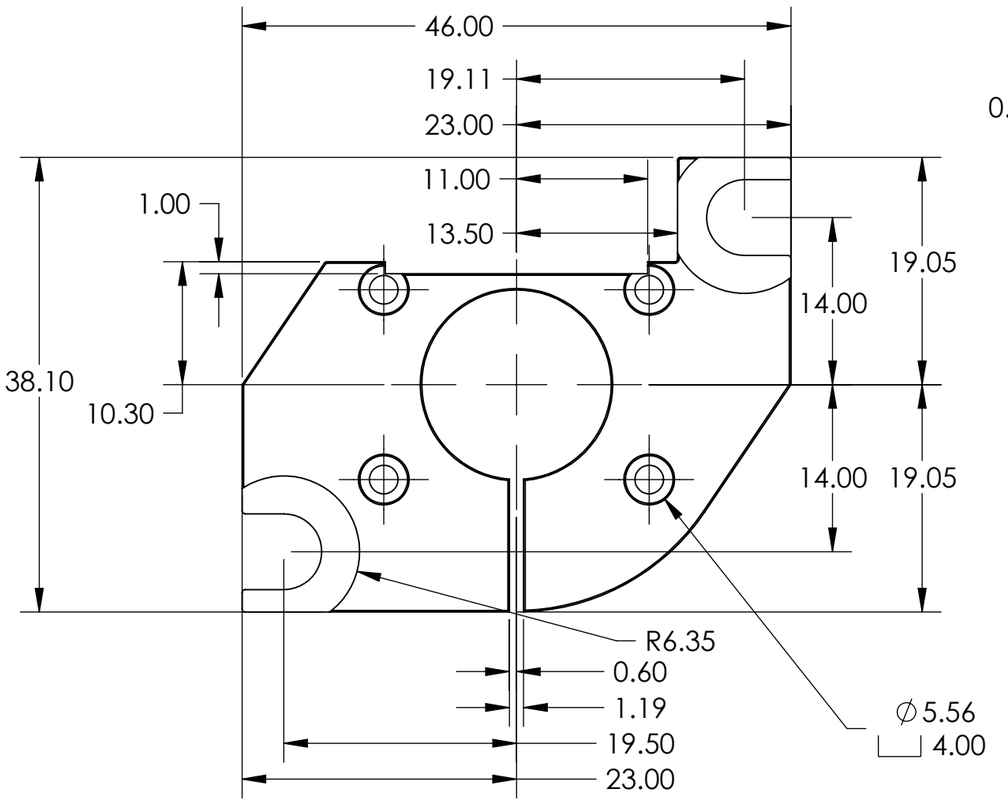
REV.	DATE	DCN #	DRAWING TREE #
-	-	-	-
-	-	-	-
-	-	-	-

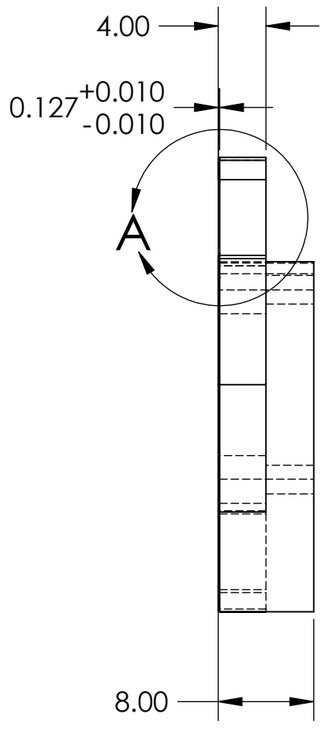


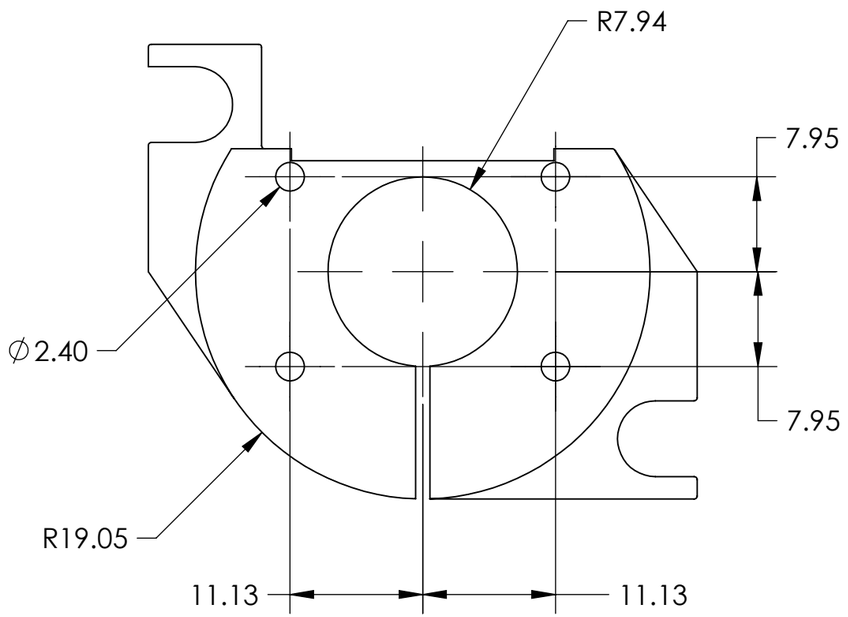


Note: The 0.005" (0.127mm) recession is a modification to v1.

DETAIL A
SCALE 4 : 1







D1001511_v2_Tip-Tilt_BOSEM_Backplate_Upper_Left, PART PDM REV: v2, DRAWING PDM REV:

NOTES AND TOLERANCES: (UNLESS OTHERWISE SPECIFIED)							
DIMENSIONS ARE IN MILLIMETERS TOLERANCES: .XX ± .05 .XXX ± .010 ANGULAR ± 0.5°	1. INTERPRET DRAWING PER ASME Y14.5-1994. 2. REMOVE ALL SHARP EDGES, R.02 MIN. 3. DO NOT SCALE FROM DRAWING. 4. ALL MACHINING FLUIDS MUST BE FULLY SYNTHETIC, FULLY WATER SOLUBLE AND FREE OF SULFUR, SILICONE, AND CHLORINE.		LIGO CALIFORNIA INSTITUTE OF TECHNOLOGY MASSACHUSETTS INSTITUTE OF TECHNOLOGY		PART NAME Tip-Tilt BOSEM Backplate - Upper Left		
	MATERIAL 6061-T6 Al	FINISH 32 µinch	SYSTEM ADVANCED LIGO	SUB-SYSTEM ISC	NEXT ASSY Tip-Tilt Structure	DESIGNER BJJ Slagmolen 21 Aug 2007 DRAFTER BJJ Slagmolen 27 Oct 2010 CHECKER APPROVAL	SIZE B DWG. NO. D1001511 REV. v2 SCALE: 2:1 PROJECTION: SHEET 1 OF 1